

Work Order ID 78311

January-05-12 8:32:14 AM

Ship March 23
78311

Page 1

Item ID: D2281

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Jack Saddle

Start Date: 05/01/2012 Start Qty: 75.00

75

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 75.00

75

Customer:

Reference:

Approvals: Process Plan: *M.C.J.*

Date: *12/01/05* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2281

Rev G

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2281 Dwg Rev: *G* Prog Rev: *G* 2-
Deburr if necessary

324.00

B 12-1-9

80

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B 12-1-9

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

812/01/10

cont
x20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78311

78311

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January-05-12 8:32:14 AM

Item ID: D2281 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Jack Saddle
 Start Date: 05/01/2012 Start Qty: 75.00 ***75*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 75.00 ***75*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per D2281 using D2281-T2								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

NIAS

Sp 12/01/12

Siz 12/01/12

80

cents
1500

W/O:		WORK ORDER CHANGES					
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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

75

Cust Item ID:

75

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Identify as per dwg & Stock Location: ST. WA. 0.00

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00


170

QC

Memo

0.00

Quality Control

12/1/16 
MF
12-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-05-12 8:32:18 AM

Page 1

Work Order ID: 78311

78311

Parent Item: D2281

D2281

Parent Item Name: Jack Saddle

Start Date: 05/01/2012

Required Date: 23/03/2012

Start Qty: 75.00

Required Qty: 75.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM
IPP: rev B 06.07.17 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	115.6000	0.125	9.868421	10.		

M304S14GA

304SS sheet .080

**

B12-1-9

Location

Loc Qty

Loc Code

MAT020

115.6

117933

19.6

119276

96

117933

(80)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78311
Description: Jack Saddle		Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.468	+/-0.010	4.475	2		✓ B62	
4.114	+/-0.010	4.112	2		✓	
2.933	+/-0.010	2.936	2		✓	
1.535	+/-0.010	1.539	2		✓	
0.354	+/-0.010	.356	2		✓	
0.354	+/-0.010	.354	2		✓	
0.604	+/-0.010	.606	2		✓	
2.000	+/-0.010	1.999	2		✓	
3.396	+/-0.010	3.396	2		✓	
3.646	+/-0.010	3.646	2		✓	
4.000	+/-0.010	4.009	2		✓	
1.525	+/-0.010	1.530	2		✓	
2.475	+/-0.010	2.477	2		✓	
Ø0.323	+0.006/-0.001	.323	2		✓	
0.080	+/-0.010	.077	2		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-1-9	Date: 12/01/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	[Signature]

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

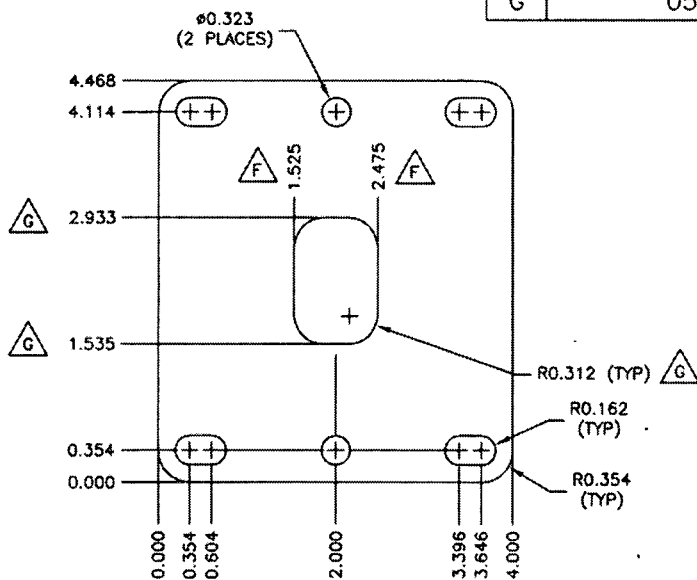
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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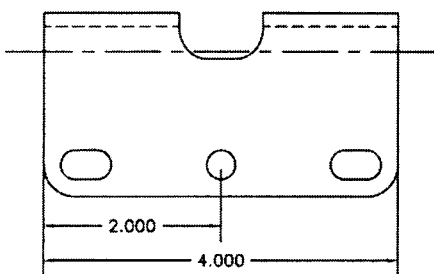


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

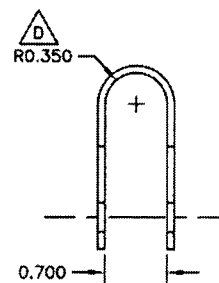
RELEASED
[Signature]
05/08/11



FLAT LAYOUT



NO. 78311-M.C.O
12/01/05



D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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